

ASAP

Dart Aerospace Ltd.

Date: Thursday, 10/11/2007 2:54:56 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 35133	
Estimate Number : 11162	
P.O. Number : <i>N/A</i>	Part Number : D32641
This Issue : 10/11/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3264 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 34243	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 11/5/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>14</i> Um: Each
Comment : Est A 04.09.02 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1250X04500	6061-T6 Bar 1.25" X 4.5"
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Comment: Qty.: 0.5097 f(s)/Unit Total: 6.1160 f(s)

Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick

(M6061T6B1.250x04.500)

Identify for D3264-1

Batch: *M105531**DJP 07/12/10*

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks: 4.500" x 1.250" x 5.700" long Bar

DJP 07/12/10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA447 and Dwg D3264

Identify as D3264-1

Deburr

J.L. / DJP 07/12/22

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L. / DJP 07/12/22

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SD 08.01/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3264-1 PAR #: N/A Fault Category: Prod / Machine ^{PAS} NCR: Yes No DQA: AD Date: 08/01/17
 QA: N/C Closed: _____ Date: _____

NCR: <u>35133</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/21	3	1 part is scrapped end-mill broke and caused deep mark in part R.C. end mill broke.	<i>[Signature]</i>	scrap + one replaced by 1 part scraped M8105531	J.L 07/12/21	<i>[Signature]</i>	<i>[Signature]</i>	07/12/21
07/12/24	30	one part has the $\phi .194"$ hole off by 0.006" over tol. R.C. part was too tight.	LE 08-01-02	Acceptable	LE 08-01-02	<i>[Signature]</i> 08/01/02	LE 08-01-02	<i>[Signature]</i>
07/12/24	30	wrong Saws were used. one part has the $\phi .194"$ hole off by 0.020" over tol. R.C. saws are abraded.	LE 08-02-02	Acceptable	LE 08-01-02	<i>[Signature]</i> 08/01/02	LE 08-01-02	<i>[Signature]</i>

NOTE: Date & initial all entries

Date: Thursday, 10/11/2007 2:54:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 35133

Part Number: D32641

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS

08-01-10

(X 14)

7.0

POWDER COATING

POWDER COATING



M106379



(14X)

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

M-J

08/01/10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-10

(X 14)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 57164

08/2/10

(14)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/11

Job Completion



08-01-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 35133
Description: Bracket		Part Number: D3264-1
Inspection Dwg: D3264	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	.691	✓			
0.063	+/-0.010	.062	✓			
0.125	+/-0.010	.127	✓			
0.875	+0.010/-0.020	.877	✓			
0.062	+/-0.010	.063	✓			
R0.03	+/-0.030	.03	✓			
R0.13	+/-0.030	.13	✓			
1.00	+/-0.030	1.010	✓			
0.125	+/-0.010	.125	✓			
0.600	+/-0.010	.599	✓			
4.000	+/-0.005	4.000	✓			
0.750	+/-0.010	.750	✓			
Ø0.194	+0.005/-0.000	.198	✓			
5.50	+/-0.030	5.501	✓			
0.125	+/-0.010	.125	✓			
0.063	+/-0.010	.064	✓			
R0.25	+/-0.030	.25	✓			
4.27	+/-0.030	4.271	✓			
R0.30	+/-0.030	.30	✓			

Measured by: J.L
Date: 07/12/21

Audited by: J.F
Date: 07/12/21

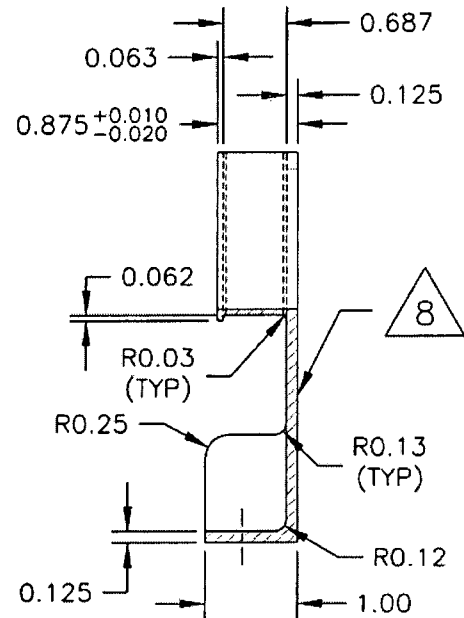
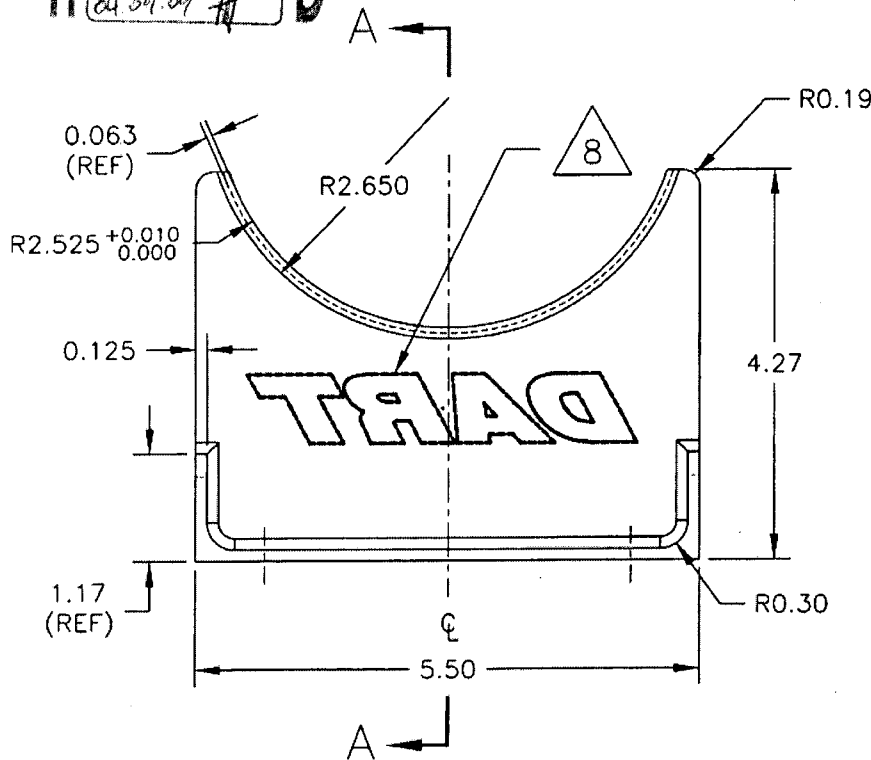
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	

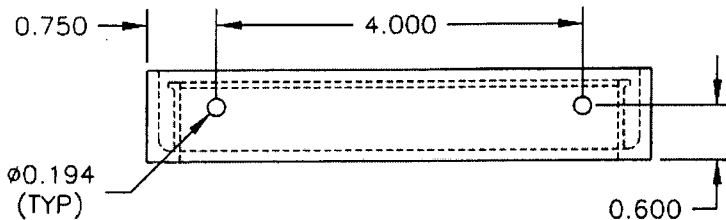


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20	TITLE BRACKET		SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED
04.04.09 JH



SECTION A-A



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35133

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